0.00

0.00

QC2- Inspect parts off machine FAI/FAIB

Memo

110

QC

110

Quality Control

		İ								DQA:	Date		
NCR: Y	es / No			,	WORK ORDER NON-C	ON	FORN	MANCE / UPDATE		·			-
		j								QA Closed:	Date	:	
Work Orde	ŕ:				DISPOSITION			AGAI	NST DE	PARTMENT,	PROCESS		
Part No. NCR No.				Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fab Use-as-is Thermoforming Finishing			Water Jet Engineering Prod. Eng. Coor. Quality Rec/Store/Packaging Other Supplier			ity		
Root Cause	Date	Step	Qty	Į.	ption of work order update or Non-conformance	1	itial ef Eng	Action Description		Sign & Date	Verification	QC Insp	ector
ooc/Data quip/Tooling Operator Material etup Other Process supplier Training	:			1 -									
					F/	AULT	CATE	GORY					
Landin	Bending Centre No	Centre Not Concentric to O/S Cracks Crushed/Crimped			General Bend BOM/Route Broken/Damaged Burrs Contamination		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance			Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	ssing	Pressure/For Temperature Weld Wrong Stock	e/Cure
	Heat Trea	1	Tube		Countersink Cut Too Short	\vdash	∕Iislabe ∕Iisread			Positioned Wrong Power Loss/Surge Other			
	Ripples in	Bend			Drill Holes		Offset	•			·· <u>· .</u>		
	Torque W	/aves in	Extrusio	n 🗀	Drawing	⊢ ⊸⊢		Calibration					
	Turning S	ſ			Finish	Щ	of S	Sequence					
	Wave/Twist in Tube				Folio		Jutside	Dimensions					

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Work Orde April-22-13 1:0	er ID 100366.		*100		Page 2			
Item ID: Revision ID: Item Name:	D4021-1 Handle Plate		Accept	*N900040	tup Start Stop	*NS1* *NS2*		
		ty: 40.00 *4(2ty: 40.00 *4(Cust Item ID: Customer:			14(1)	
Approvals:	Process Plan:			Date:	- Ru	n Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center II 120 *120 CONTRACTOR OF THE PROOF THE PRO	•		Set Up/ Run Hours 0.00	Tool ID Tool #	A		Reject Insp. Number Stamp	
140 *1 △ ↑ Packaging Packaging	Identify as	per dwg & Stock Location.	0.00 0.00		5yx		13-4-8	
150 *150* QC Quality Control	QC21- Fin.	al Inspection - Work Order Release Memo	0.00		· .	13/1	5/6 D mx 13-4-2	

NCR: Yes / No					WORK ORDER NON-C	CONF	ORN	MANCE / UPDATE		QA Closed:	Da	ate:		
Work Orde	er:				DISPOSITION					PARTMENT	/PROCESS			•
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstul Machining Small F Thermoforming Finishi Large Fab Composi		ab ing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other		
Root				1	ption of work order update	Init		Action		Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Description		Date	Verification	on	QC Inspector	_
Doc/Data							ļ					Ì		
Equip/Tooling														
Operator]	1							
Material												1		
Setup		1 1					1							
Other										! 		Ì		
Process		1												
Supplier				ļ ļ										
Training														
Unapproved						<u> </u>							,	_
					F	AULT (ATE	GORY						_
Landi	ng Gear				General				_	-				
	Bending				Bend	Gr	ain		L	Ovalized			Pressure/Forced	
	Centre No	ot Conce	ntric to	o/s	BOM/Route	На	rdwa	re		Over/Under	tolerance		Temperature/Cure	
	Cracks	į			Broken/Damaged	Ins	pecti	on Incomplete		Part Incorred	ct		Weld	
	Crushed/	Crimped			Burrs	ins	truct	ions Incomplete/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled	
	Cuffs				Contamination	М	ainte	nance		Part Moved				
	Heat Trea	at			Countersink	М	slabe	eled		Positioned V	Vrong			
1	Inspection	n Strip in	Tube		Cut Too Short	М	sread	j [']		Power Loss/	Surge		Other	
	Ripples in				Drill Holes	Of	fset							
	Torque W		Extrusio	n	Drawing	T or	it of C	Calibration						
	Turning S	- 1		<u> </u>	Finish		it of S	Sequence						
	Waye/Twist in Tube			-	Folio	По	ıtside	Dimensions						•

DQA:

Date:

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Page 1

Work Order ID:

100366

Parent Item:

D4021-1

Parent Item Name:

Handle Plate

Start Date: 4/22/13

Required Date: 5/03/13

Start Oty: 40.00

Required Qty: 40.00

Comments:

IPP RevA: new issue DD 09.11.25 verified by:EC

IPP Rev:B as per dwg REV.A DD

10.02.22 verified by EC IPP Rev:C as per dwg revB DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	199.0300	0.1225	5.157896			
304/316 0.125 Sheet										<i>!</i> \$\$6			JM 13-4-28

Location Loc Oty Loc Code MAT020 199.03 122521 24.93 124445 124445 174.1

NCR: Y	res / No				WORK ORDER NON-O	100	NFORM	MANCE / UPI	DATE	QA Closed:	Date:				
Work Orde	er:				DISPOSITION	,				DEPARTMENT/PROCESS					
Part No.			Rework Scrap Use-as-is	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing		4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other							
NCR N	No	·	·		Work Order Update]		Large Fab	Composite		Supplier				
Root				Descri	ption of work order update	1	nitial	Act		Sign &					
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector			
Doc/Data						1									
Equip/Tooling			1 1												
Operator															
Material															
Setup															
Other						1									
Process															
Supplier															
Training															
Unapproved		1						<u></u>		<u></u>					
		<u> </u>				AUL	T CATE	GORY							
Landi	ng Gear				General		1		_	7	<u></u>	la <i>1</i> 5 1			
	Bending				Bend	\vdash	Grain		·	Ovalized		Pressure/Forced			
	Centre N	lot Conce	entric to (^{D/S} -	BOM/Route	<u> </u>	Hardwa			Over/Under		Temperature/Cure			
,	Cracks	.		<u> </u>	Broken/Damaged	\vdash	4 '	ion Incomplete	⊢	Part Incorred		Weld			
		/Crimped	ı	<u> </u>	Burrs	\vdash	-	tions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
	Cuffs			⊢	Contamination	\vdash	Mainte		<u> </u>	Part Moved					
	Heat Tre	i		·	Countersink	-	Mislabe		 	Positioned V		loshor.			
	Inspection	} '	n Tube		Cut Too Short	\vdash	Misread	.		Power Loss/	oni Be	Other			
	Ripples i	Į.			Drill Holes	\vdash	Offset	Calibantia -							
		Naves in		ነ <u> </u>	Drawing	1	4	Calibration							
	Turning Sequence Finish					\perp	Tout of 3	Sequence							

Outside Dimensions

DQA:

Date: ____

Wave/Twist in Tube

Folio

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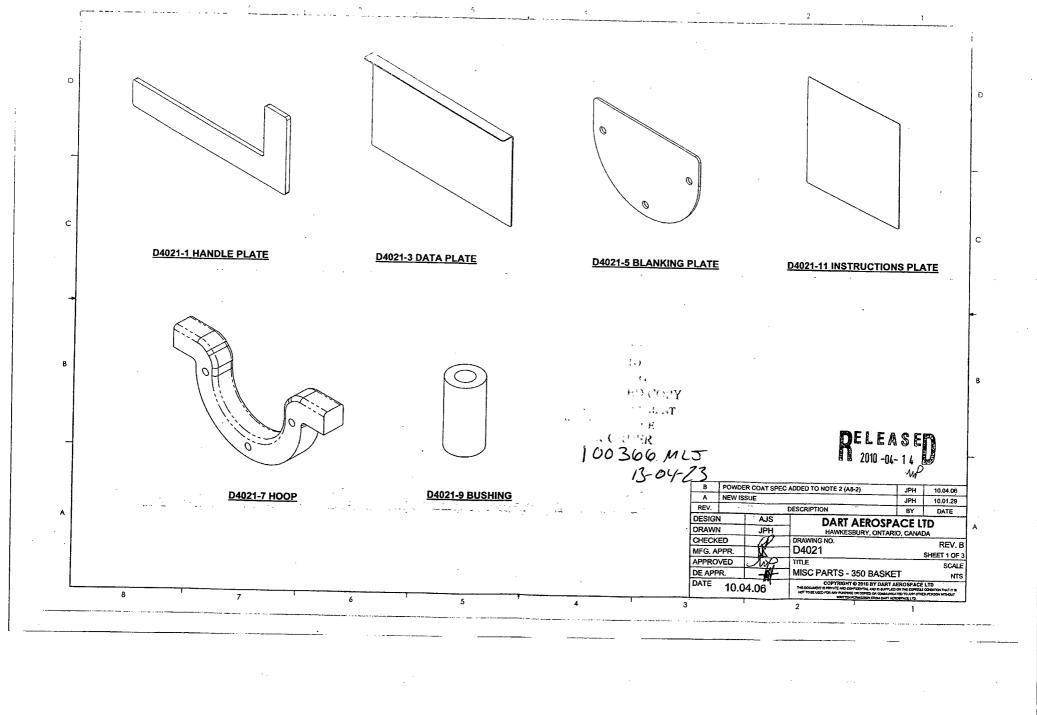
DART AEROSPACE LTD	Work Order:	100366
Description: Handle Plate	Part Number:	D4021-1
Inspection Dwg: D4021 Rev: B		Page 1 of 1

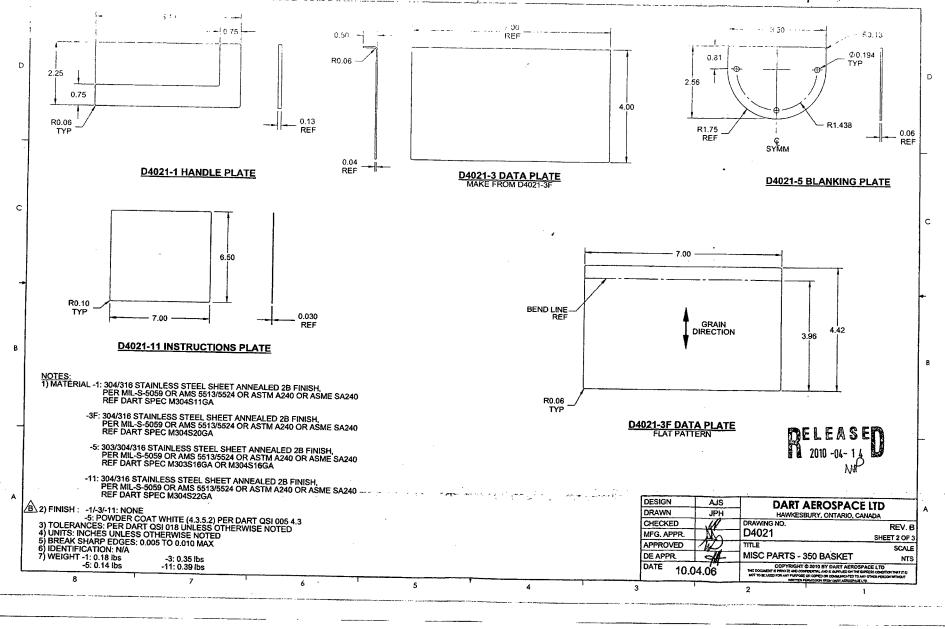
FIRST ARTICLE INSPECTION CHECKLIST

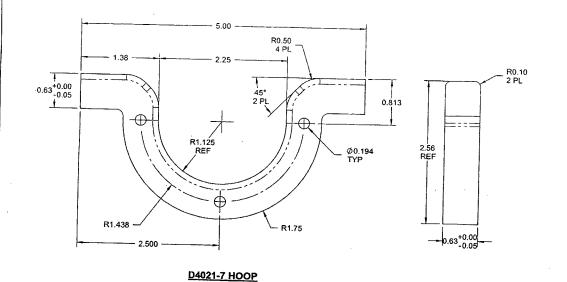
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.13	+/-0.030	5.126"	-		V	Thmoi
0.75	+/-0.030	0,754"	-		· V	
2.25	+/-0.030	2.2542	_		v	······································
0.75	+/-0.030	0.7567	_		V.	
0.125	+/-0.010	0.117)		V	
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sured by: J		Audited by:	27	— п	Preliminary A	

				1	
Measured by:	Jm	Audited by:	27	Preliminary Approval:	
Date:	13-4-28	Date:	13 429	Date:	

Rev	Date	Change	Revised	by	1	Approved
A	10.06.08	New Issue	KJ (T)	1	122
			.1	1/^	/ —	







Ø0.191 ~ Ø0.38 D4021-9 BUSHING

NAP

DESIGN AJS DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN JPH CHECKED DRAWING NO. REV. B D4021 MFG. APPR. SHEET 3 OF 3 APPROVED TITLE SCALE DE APPR. MISC PARTS - 350 BASKET NTS COPYRIGHT @ 2010 BY DART AEROSPACE LTD DATE 10.04.06

NOTES: 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IVA
7) WEIGHT -7: 0.80 lbs

C

-9: 0.02 lbs